

Date: Monday, 9/10/2007 1:19:02 PM
 User: Kim Johnston

Process Sheet

SPLIT-3

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 34476 -12		
Estimate Number	: 12883		
P.O. Number	: N/A	Part Number	: D3560043
This Issue	: 9/10/2007 S.O. No. : N/A	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B1
Previous Run	: 32646	Material	: N/A
Written By	:	Due Date	: 9/17/2007
Checked & Approved By	:	Qty:	X
Comment	: Est Rev:A New Issue 07.05.24 EC	Um:	Eac
2			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"	
	Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s)	6061-T6 Bar .50" x 5.0"	
	6061-T6 Bar .50" x 5.0"		
	Batch: M1051c46		
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW		
	Cut blanks 15.500" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	1- Mill as per Folio FA695 Rev: A & Dwg D3560 Rev: C		
	2-C'sink 0.196" hole on manual mill as per dwg D3560		
	3-Deburr per dwg D3560		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		
	J.F	07/09/23	

the 1st of May 1861, we were told that the rebels had taken over the fort at Manassas, and that they were marching on Washington. We were told that the rebels had taken over the fort at Manassas, and that they were marching on Washington. We were told that the rebels had taken over the fort at Manassas, and that they were marching on Washington.

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

PLATE 334476-0834478 (2)

07.10.29 (2)

07.10.29 (2)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

07.10.29 (2)

07.10.29 (2)

1-Weld assembly as per dwg D3560

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.10.29 (2)

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.10.29 (2)

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FJ 07/11/01 (2)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

NA C 07.10.29

07/11/01 (2)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BP 07.11.01 (2)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

07.11.01 (2)

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

F09/11/02

Job Completion



J 09.11.02

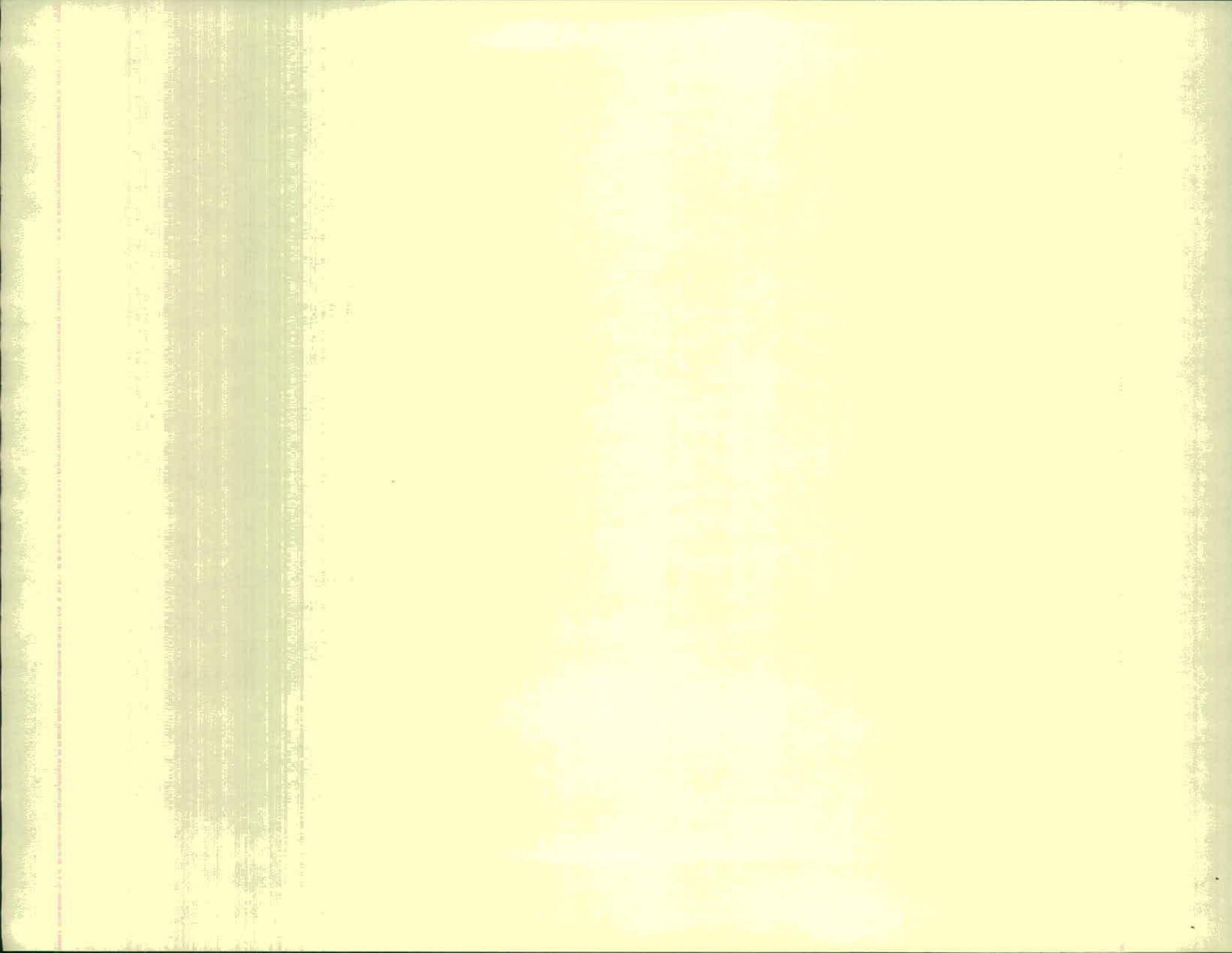
DART AEROSPACE LTD	Work Order:	34476
Description: Arm	Part Number:	D3560-3
Inspection Dwg: D3560 Rev: B		Page 1 of 1

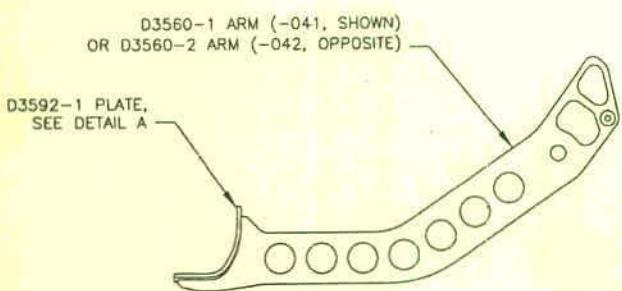
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

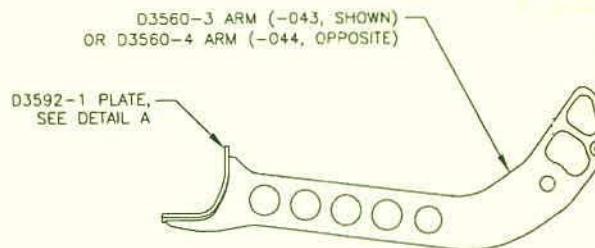
Measured by:	J.L./S.F.	Audited by:	BG	Prototype Approval:	N/A
Date:	07/09/21	Date:	07-09-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	E

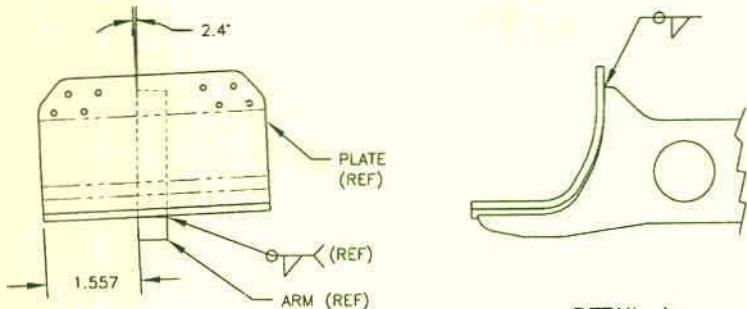




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HARVESTER, ONTARIO, CANADA
DATE	TITLE	REV. C SHEET 1 OF 3
07.06.19	ARM WELDMENT	SCALE 1:1

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CC
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34476

